

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000133**Date Inspected:** 27-Apr-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, CA**CWI Name:** Michael Johnson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) Tests**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Mary Madere is present at the Ironworkers Apprenticeship Training Facility as requested by ABF for the continuing purpose of witnessing Procedure Qualification Record tests. On this date, the QA Inspector observed the following personnel present: Smith-Emery Companys Quality Control (QC) Representative Certified Welding Inspector (CWI) Mr. Michael Johnson, ABF Representative Mr. Tommy Gibson, Bay Arc Representative Mr. Rich Deveau and welder Mr. Dan Gordon.

The QA Inspector witnessed the completion of the second attempt of the Procedure Qualification Record (PQR) Test identified as ABF-PQR-014-1. This PQR test is being attempted using the flux-cored arc welding (FCAW-G) process with gas shielding and a mechanical device that travels on a magnetic track. Welder Mr. Dan Gordon completed eight weld passes on this date. For specific welding parameters recorded during this PQR and digital photographs that support these observations, see Caltrans Welding Witness Report, TL-6032 generated on this date.

PQR Test Summary

Based on the Caltrans QA Inspectors observations starting from the first date of these PQR test attempts on 03-26-2007 through present date, thirteen PQRs have been attempted.

- Six (6) of the thirteen (13) PQR tests were found to be visually non-compliant by Quality Control.
- Six (6) of the thirteen (13) PQR tests complied with the welding parameter and visual requirements, however did not comply with radiographic testing requirements.
- One (1) of the thirteen (13) PQR tests completed is currently pending radiographic testing. This is the PQR test completed on this date.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

There have been no PQR tests found to be compliant with all of the requirements of the contract documents.

Summary of Conversations:

ABF Representative Mr. Tommy Gibson informed the QA Inspector that they will start a new PQR on Monday, April 30, 2007.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Madere,Mary	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
